

Date: Thursday, 02/10/2008 10:35:05 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WEARPLATE		
Job Number	: 42418			Part Number	: D37911		
Estimate Number	: 13309			Drawing Number	: D3791 REVA		
P.O. Number	:			Project Number	: N/A		
This Issue	: 02/10/2008	S.O. No.	:	Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 10/10/2008		
Previous Run	: 39694			Qty:	20	Um:	Each
Written By	:						
Checked & Approved By	: <u>JUL 08.10.02</u>						
Comment	: Est Rev:A 08-05-13 new issue DD verified by:EC						
	: Est Rev:B 08-05-22 revA as per dwg ECN1191 DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 Sheet .063
Comment: Qty.: 0.3063 sf(s)/Unit Total : 6.1257 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <u>1091057</u> <u>B 8-10-6</u> <u>B 8-10-7</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3791 Dwg Rev: <u>A</u> <u>B 8-10-6</u> <u>B 8-10-7</u> Prog Rev: <u>A</u> 2-Deburr if necessary <u>B 8-10-6</u> <u>B 8-10-7</u>		

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D3791 using Jigs

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3791-1 PAR #: N/A Fault Category: Prod/Fab Ass' med Snell NCR: Yes No DQA: Date: 08/16/16
 Resolution: Scrap Disposition: QA: N/C Closed: Date: 08/16/16

NCR: 42418		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.10.06	3	Parts out of tolerance R/C employee lowers his tool offset after noticing that all his hole size were	P&H QSI 042 08.09.06 10	Recommend scrap b/c parts from waterjet are out of tolerance and not the same each time.	FB 8-10-06	S 08/10/06	P&H 08.09.06 QSF 042	S 08/10/06
		Close to the highest tol.		- Remind employee that hole size are ok to be at the top of the tol.				S 08/10/06

NOTE: Date & initial all entries

Date: Thursday, 02/10/2008 10:35:06 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 42418

Part Number: D37911

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



checked

S 08/10/15 P25

Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1-Weld hardcoat as per dwg D3791 QSI004

Hardcoat 2059b Batch: M109303

FL 08-10-15

25

8.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/10/15

P25

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/15

P25

10.0 POWDER COATING

POWDER COATING



M 106442

25X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

9:20

OVEN TEMPERATURE:

320°F

FINISH TIME:

9:50

m/f 08/10/15

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/10/15

25

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker and Stock

Location: FP-17

FL 08/10/15

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WEARPLATE

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Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC21

FINAL INSPECTION/W/O RELEASE



08/10/16 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 28.10.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

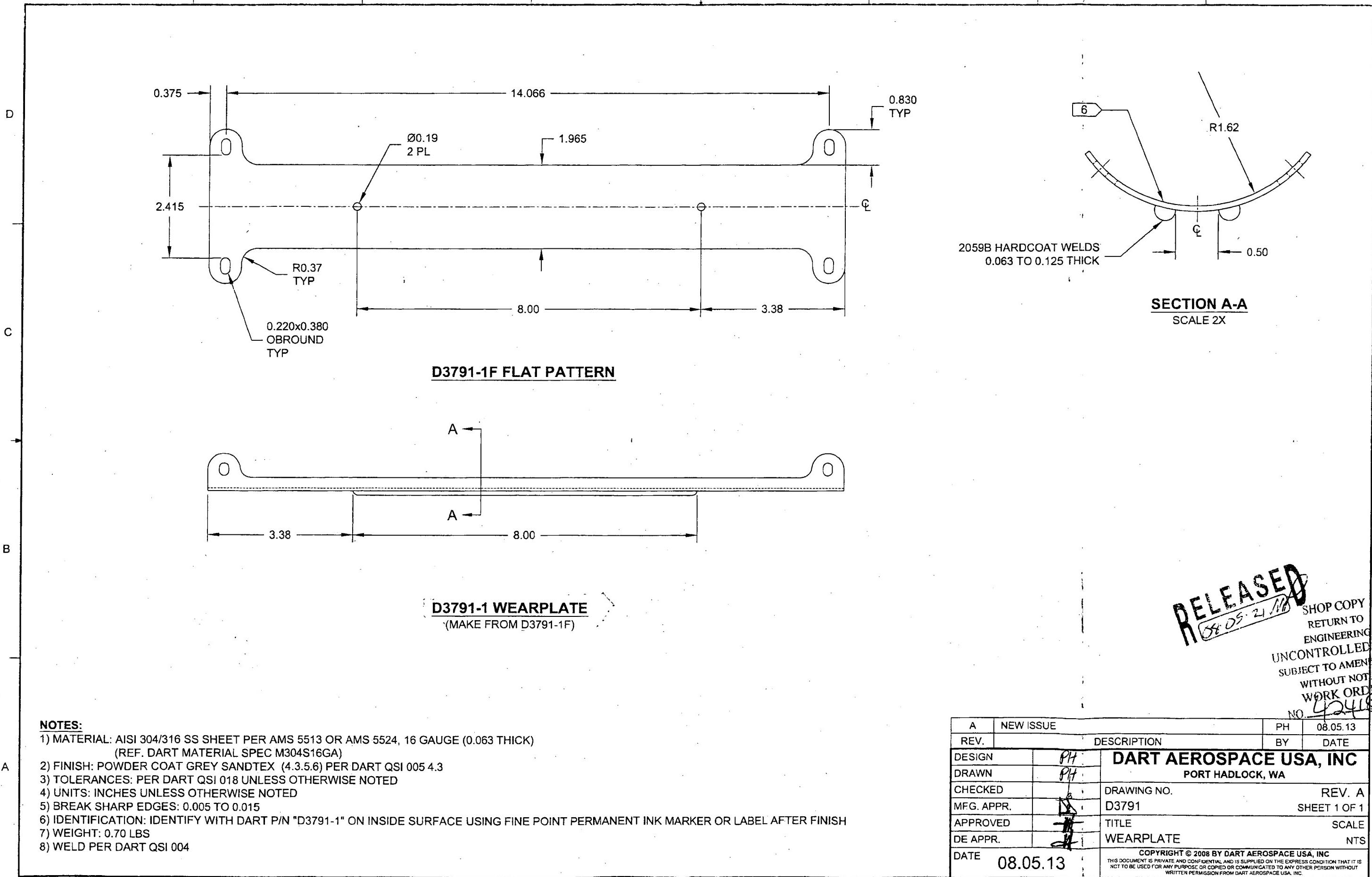
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

DART AEROSPACE LTD	Work Order:	42418
Description: WEAR PLATE	Part Number:	D 3791-1
Inspection Dwg: 3791-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	HB	Audited by:	D	Prototype Approval:	N
Date:	8-10-7	Date:	06/10/02	Date:	4

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	